

Work Order ID 71779

Tuesday, July 12, 2011 8:11:30 AM



Page 1

Item ID: D2012-106

Accept



Setup Start



Revision ID: ~~PRELIM~~

Stop



Item Name: Arm

Start Date: 7/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/12/2011 Req'd Qty: 1.00



Customer:

~~PRELIMINARY ISSUE~~

Reference:

Run Start



Approvals: Process Plan: UMF

Date: 11-07-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2012-106	PA1 <u>A ASS</u>

100 0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch to length as per Dwg D2012-106 & template D2012-106T1

① 12 11.07.11

110 0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Debur

① 12 11.07.11

120 0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

11 07 12 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71779

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Start Date: 7/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/12/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00
320°F
9:30

IX ✓ M-7/11/07/12

140

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

① B 11.02.12

150

Identify as per dwg & Stock Location:

0.00



Packaging

Packaging

Memo

71804

✓ 7/12/12 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Tuesday, July 12, 2011 8:11:30 AM



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Item ID: D2012-106

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Arm

Start Date: 7/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/12/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/12

POSITIVE RECALL

EFFECTIVE 11/7/12 AUTH

RELEASED DATE 11.07.12

MF
11-07-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, July 12, 2011 8:11:26 AM

Page 1

Work Order ID: 71779



Parent Item: D2012-106



Parent Item Name: Arm



Start Date: 7/12/2011

Required Date: 7/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.07.12 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035 		Purchased	No			100	f	175.7796	2.651	2.790526			
304 RD Tube .500 x .035W													

Location

Loc Qty

Loc Code

MAT017

175.779638

115535

2.33

116720

1.66068

117598

171.788958

~~5~~

11.07.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

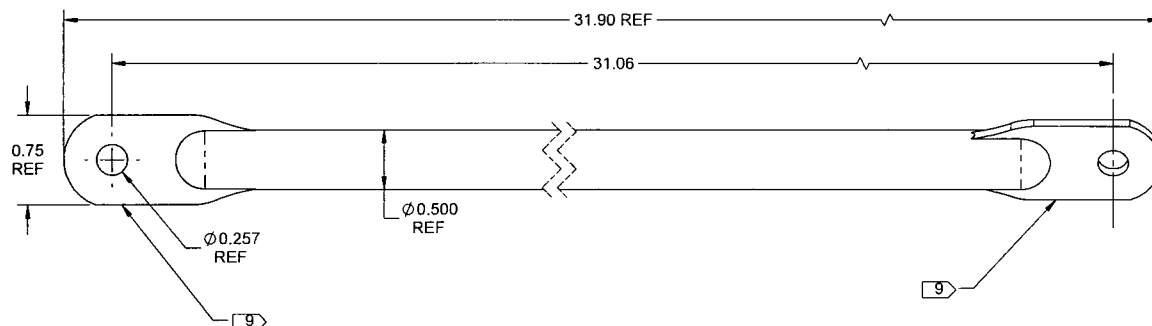
8 7 6 5 4 3 2 1

D

C

B

A



D2012-106 ARM

PRELIMINARY A1
11.07.11 AJ5

71779

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBE $\phi 0.500 \times 0.035$ WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2012-106" USING REMOVABLE TAG
- 7) WEIGHT: 0.47 LBS (APPROX)
- 8) MAKE PER TEMPLATE DT8116
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727
- 10) NOTE THIS IS THE LH INSTALLATION VERSION OF D2012-105

PA1	PRELIMINARY	AJS	11.07.11
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D2012-106	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

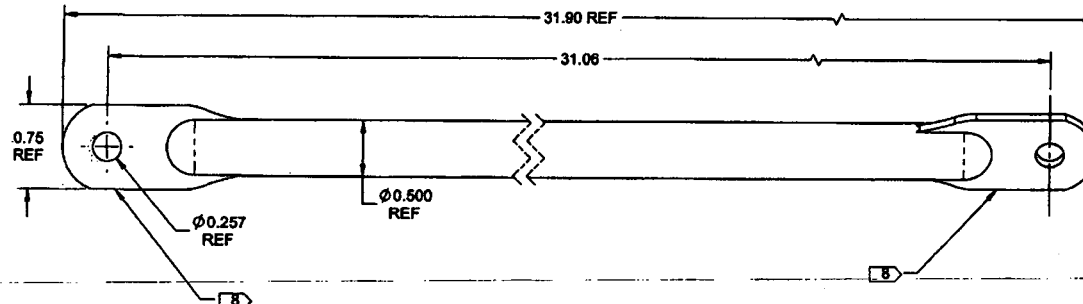
D

C

C

B

B



D2012-106 ARM

RELEASED
2011-07-12

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBE $\phi 0.500 \times 0.035$ WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2012-106" AND B/N "BXXXXX" PER DART QSI 044 6.1 USING REMOVABLE TAG
- 7) WEIGHT: 0.47 LBS (APPROX)
- 8) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727
- 9) NOTE THIS IS THE LH INSTALLATION VERSION OF D2012-105

A		NEW ISSUE		AJS	11.07.11	
REV.		DESCRIPTION			BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
DRAWN	AJS					
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A			
MFG. APPR.	<i>[Signature]</i>	D2012-106	SHEET 1 OF 1			
APPROVED	<i>[Signature]</i>	TITLE	SCALE			
DE APPR.	<i>[Signature]</i>	ARM	NTS			
DATE		11.07.11				
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8 7 6 5 4 3 2 1